

Order ID 70590

June 13, 2011 11:23:22 AM



Page 1

D412-630-032

Accept



Setup Start



Stop



Revision ID:

Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00

Required Date: 6/22/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

5/17/13

OK for CR 11/04/07

110

0.00



Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch: 11/4830

PS 11/07/08 (1)

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

5/17/08

GD
RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70590

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Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Pick Kit	0.00							
Packaging	Memo	0.00				11/2/11	KSP		
Packaging									
140 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00				41			
Quality Control						RH			
150 	Packaging	0.00							
Packaging	Memo	0.00				11/7/11	KSP		
Packaging	Identify and pack for shipping as per PPP D412-630-032								
	Location: _____								
	PPP Rev: <u>D</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70590

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Page 3

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/07/08
MF
11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)




Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
 10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
 removed qty1 an310-4 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4  NUT		Purchased	No			110	Each	35.0000	1	1		6/11/07/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		35							
				117795		15							
				117872		20							
MS24665-302  Cotter Pin		Purchased	No			110	Each	204.0000	1	1		6/11/07/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST309		4							
				113644		4							
				ST357		200							
				117460		200							
AN310-5  NUT		Purchased	No			130	Each	20.0000	2	2		11/7/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		20							
				114830		20							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

130 Each

1,757.000

3 3

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1750

116419

96

116549

54

117343

500

117508

300

117764

300

117872

500

AN44-C12

Purchased

No

130 Each

23.0000

eyebolt

Location

Loc Qty

Loc Code

ST362

23

114669

3

117616

20

AN4C15

Purchased

No

130 Each

15.0000

BOLT

Location

Loc Qty

Loc Code

ST358

15

117764

15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN5C11
BOLT

Purchased No 130 Each 33.0000

1 1
1 1

Location Loc Qty Loc Code

ST337 33
113950 3
114801 30

AN5C15
BOLT

Purchased No 130 Each 27.0000

1 1
1 1

Location Loc Qty Loc Code

ST338 27
114669 7
117616 20

AN960C10 NAS1149C0363 R

Purchased No 130 Each 0.0000

7 7

WASHER
AN960C516
WASHER

Purchased No 130 Each 39.0000

1 1
1 1

Location Loc Qty Loc Code

ST347 39
102842 39

D3454-1
Bushing

Manufactured No 130 Each 20.0000

1 1
1 1

Location Loc Qty Loc Code

ST054 20
58555 20

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3454-3

Manufactured No

130

Each

10.0000



Bushing

Location

Loc Qty

Loc Code

ST058

10

56420

10

Manufactured No

130

Each

12.0000

D3454-5



Bushing

Location

Loc Qty

Loc Code

ST054

12

68468

12

Manufactured No

130

Each

7.0000

D3455-1



Spacer

Location

Loc Qty

Loc Code

ST054

7

68469

7

Manufactured No

130

Each

21.0000

D3455-3



Spacer

Location

Loc Qty

Loc Code

ST054

21

68470

21

Manufactured No

130

Each

0.0000

D3462-042



Bracket Assembly

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

130

Each

353.0000

3

3



Nut



M1180778

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

273

112314

273

MS24665-227

Purchased

No

130

Each

28.0000

2

2



COTTER PIN



2

Location

Loc Qty

Loc Code

ST309

28

113845

28

NAS1515H5

Purchased

No

130

Each

123.0000

1

1



Washer



2

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

D3455-1

Manufactured

No

110

Each

7.0000

2

2



Spacer



2

Location

Loc Qty

Loc Code

ST054

7

68469

7

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3443-041



Strut Weldment Assembly

Manufactured No

110 Each 0.0000

1

B 70524

(12)



EP 11/07/08

D3463-042



Step Weldment Assembly

Manufactured No

110 Each 1.0000

1



EP 11/07/07

B 70531 (12)

Location

Loc Qty

Loc Code

ST494

1

68473

1

D3443-9



Pin

Manufactured No

110 Each 4.0000

2



EP 11/07/07

Location

Loc Qty

Loc Code

ST053

4

68475

4

AN4C14



BOLT

Purchased No

110 Each 39.0000

1



EP 11/07/07

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

14

114669

14

MS24665-229



COTTER PIN

Purchased No

130 Each 123.0000

2



11/7/07

Location

Loc Qty

Loc Code

ST309

123

111041

123

2

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

 MS24665-227
 COTTER PIN

Purchased No 110 Each 28.0000 1

Location Loc Qty Loc Code

ST309 28
113845 28

 AN4CH3
 SS Bolt

Purchased No 110 Each 21.0000 2

Location Loc Qty Loc Code

ST355 1
114801 1
ST357 20
117616 20

 D3465-1
 Washer

Manufactured No 110 Each 18.0000 1

Location Loc Qty Loc Code

ST054 18
46134 18

 AN310-4
 NUT

Purchased No 130 Each 35.0000 1

Location Loc Qty Loc Code

ST324 35
117795 15
117872 20

 D3443-043
 Strut Weldment Assembly

Manufactured No 110 Each 0.0000 1

B69945

Monday, June 13, 2011 11:23:30 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:23:30 AM

Page 8

Work Order ID: 70590

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3454-7

Manufactured No

110

Each

2.0000

2

2



Bushing



6/14/07/07

Location

Loc Qty

Loc Code

ST054

2

59256

2

2

AN310-7

Purchased

No

110

Each

41.0000

1

1



NUT



6/14/07/07

Location

Loc Qty

Loc Code

ST324

41

114784

41

1

Monday, June 13, 2011 11:23:30 AM

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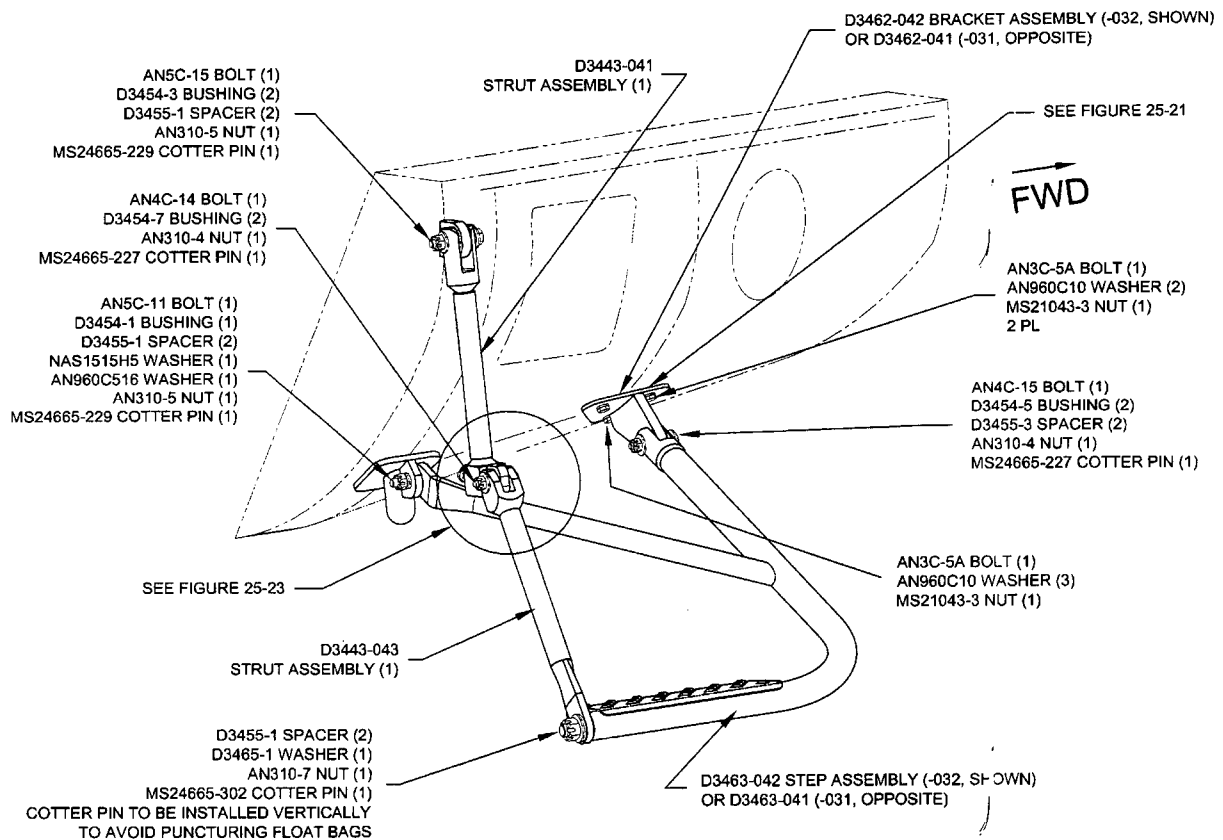
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

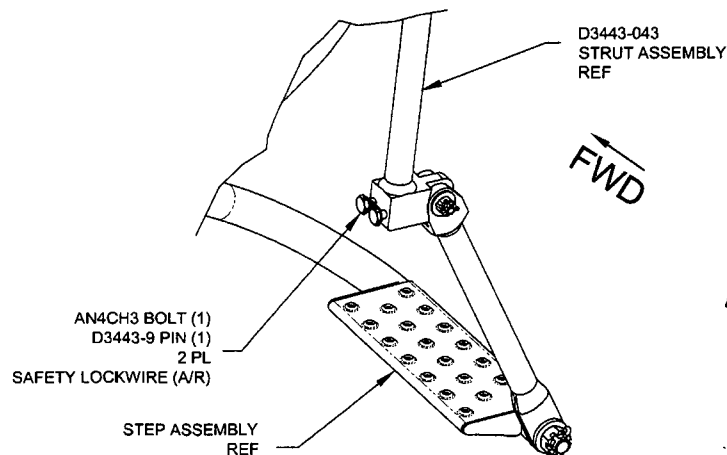
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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25-00-00

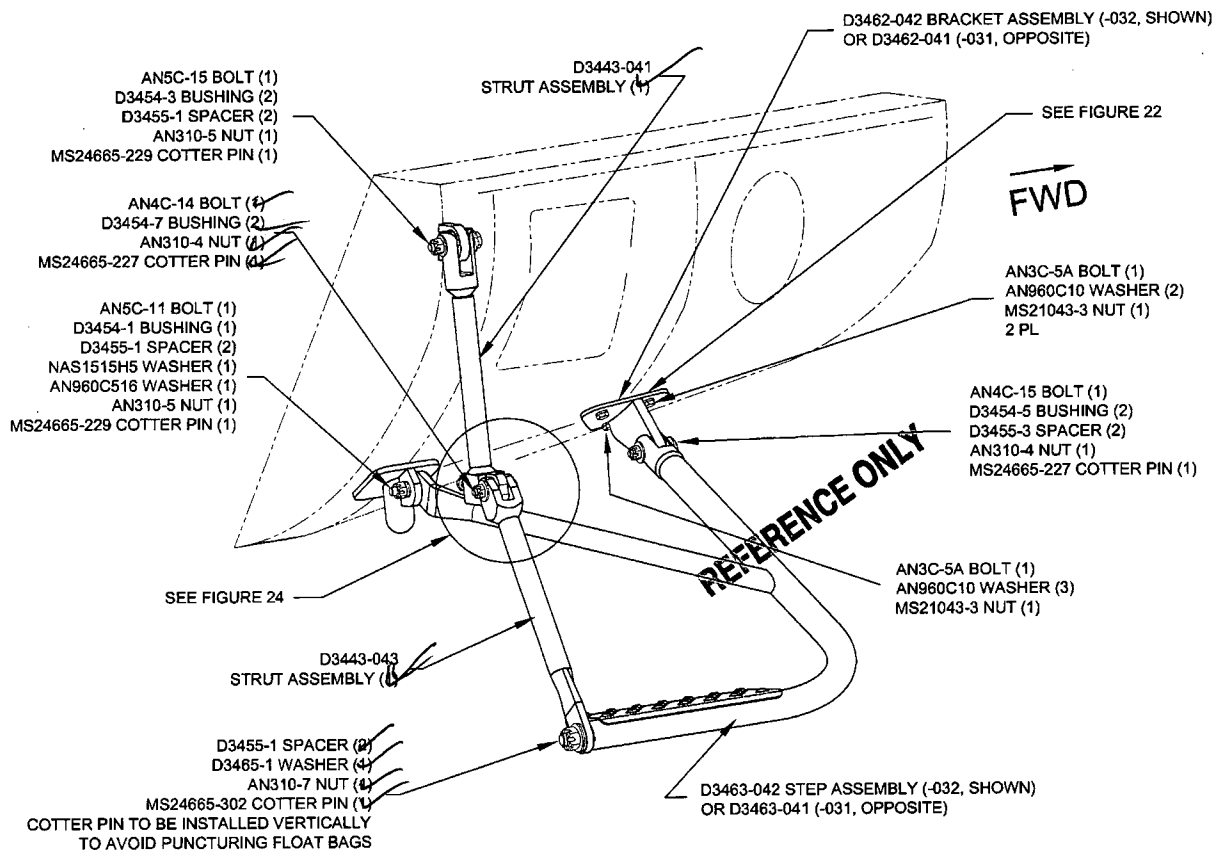


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

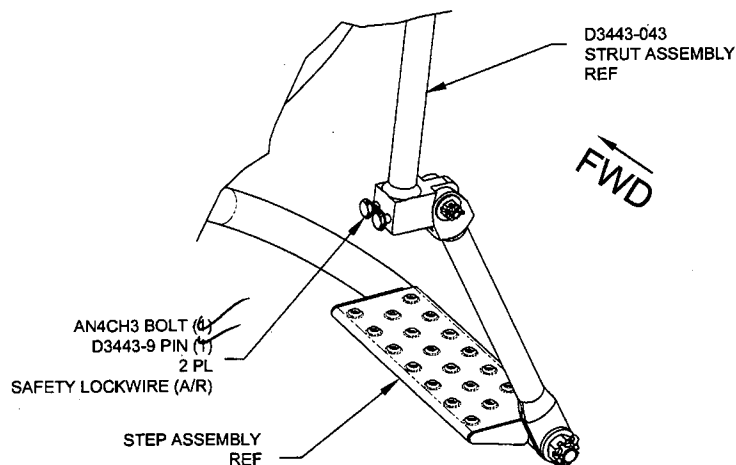


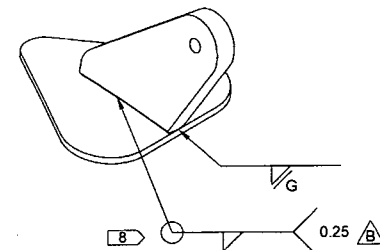
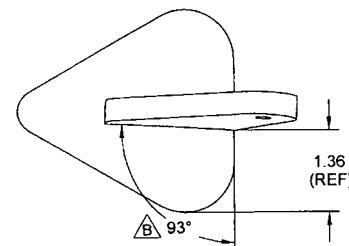
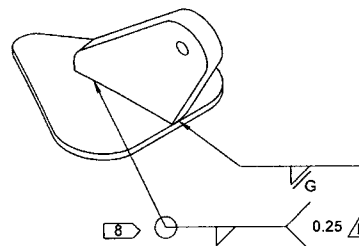
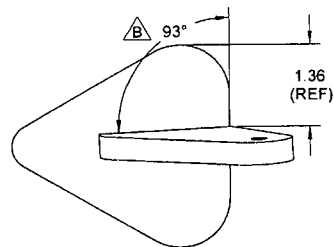
FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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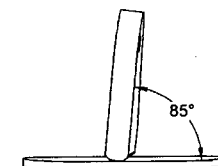
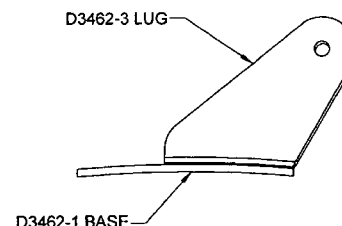
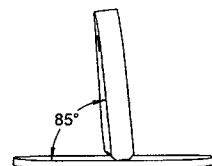
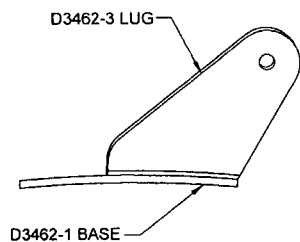
Revision: M
Date: 08.12.12

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
4	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
1 6 (4)	6	D3455-1	SPACER (-2)
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
4	1	D3465-1	WASHER
2 (1)	2	AN310-4	NUT (-1)
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2 (1)	2	MS24665-227	COTTER PIN (-1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP



REFERENCE ONLY
REFERENCE ONLY



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	VIP DC.		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 TITLE BRACKET ASSEMBLY SCALE 1:2 <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			